

Work Order ID 60338

July 6, 2010 7:29:12 AM



PRELIMINARY ISSUE Page 1

Item ID: D4102-2

Accept



Setup Start



Revision ID: SHIM

Stop



Item Name:

Start Date: 07/07/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 28/07/2010 Req'd Qty: 2.00



Customer:



Reference: *Jul 10.07.06*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4102	REV.PRELIM <i>PAY</i>

100	Cut blanks as per folio	0.00							
	Bandsaw	0.00							
Jaspa Bandsaw	Memo 4.950" long								

amk 10/67/09

2

110		0.00							
	HAAS 1	0.00							
HAAS CNC vertical machine #1	Memo MILL AS PER DWG AND FOLIO FA945 FOLIO REV: <i>3A</i> DWG REV: <i>PAY</i> DEBURR								

amk 8/10/07/15

2

Work Order ID 60338

July 6, 2010 7:29:12 AM



Page 2

Item ID: D4102-2

Accept



Setup Start



Revision ID: SHIM

Stop



Item Name:

Start Date: 07/07/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 28/07/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

SP 10/07/15

2

Ø



QC

Memo

0.00

Quality Control

□□

130

QC8- Inspect parts - second check

0.00

- inspection to pay day only

Siobhán 15 (2)

(2)



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

W 10/07/19

x2

Ø



HandFinish

Memo

0.00

Hand Finishing

Work Order ID 60338

July 6, 2010 7:29:12 AM



Page 3

Item ID: D4102-2

Accept



Setup Start



Revision ID: SHIM

Stop



Item Name:

Start Date: 07/07/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 28/07/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

→ inspect to PA 4



QC

Memo

0.00

Dy only

Quality Control

8/10/19

160

Identify as per dwg & Stock Location: *Red*

0.00



Packaging

Memo

0.00

7/10.07.21

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

*At pay test.
10.07.22
Conformity
ReQA
10.07.30*

Quality Control

*MO
10-7-21*

Picklist Print

July 6, 2010 7:29:12 AM

Page 1

Work Order ID: 60338



Parent Item: D4102-2



Parent Item Name:

Start Date: 07/07/2010

Required Date: 28/07/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-07-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X04.00 0		Purchased	No				f	16.5000	0.042	0.088421			



6061-T6 Bar .250 x 4.00

Location

Loc Qty

Loc Code

MAT

16.5

110680

0.5

114608

16

04421
04421
10/07/09

POSITIVE RECALL

EFFECTIVE 10.07.06 AUTH

RELEASED DATE

DART AEROSPACE LTD		Work Order: 60338
Description: SKIM		Part Number: 0402-2
Inspection Dwg: 0402 Rev: PA4		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

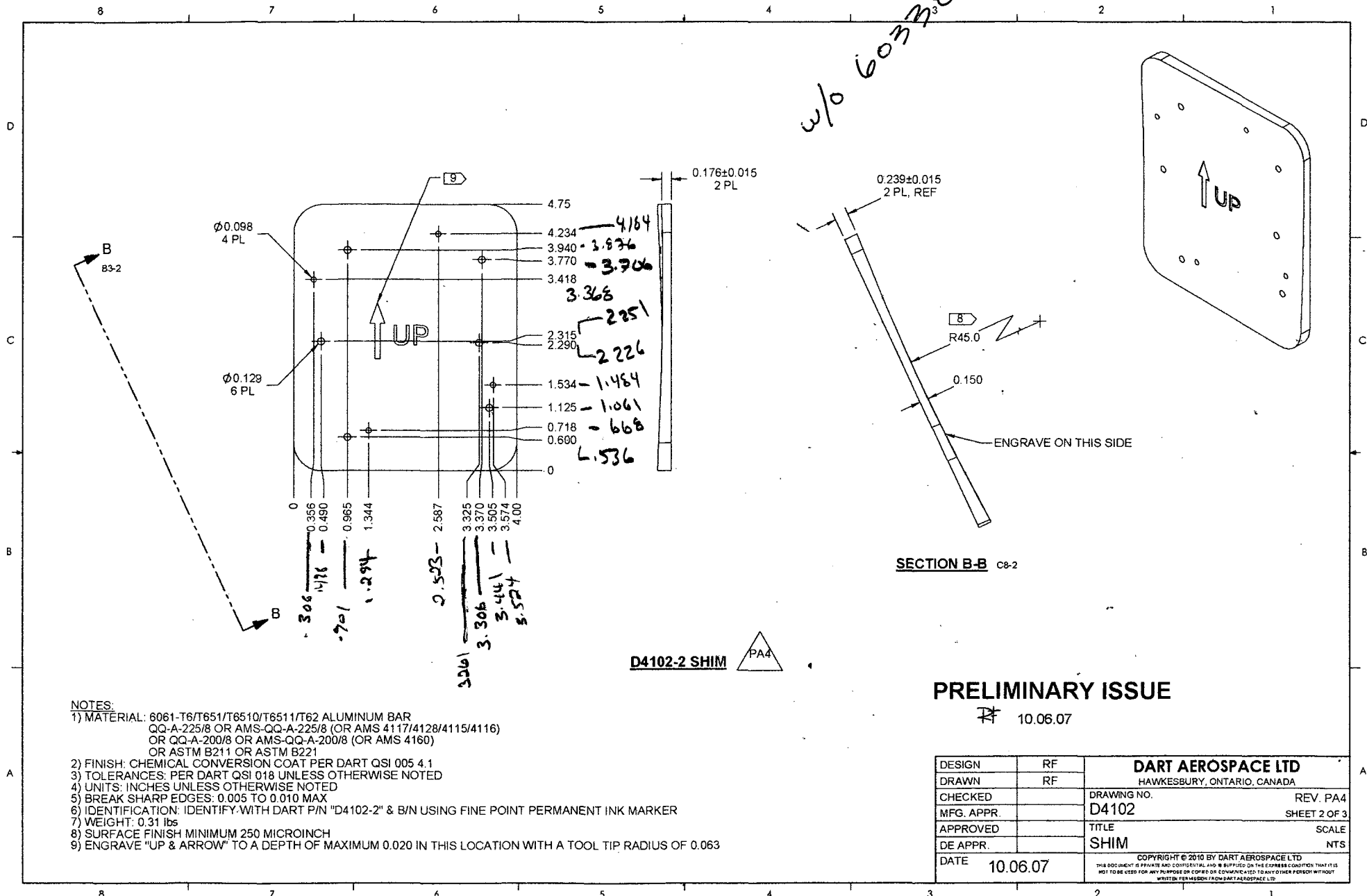
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
356	±.010	356	✓		VERN	
.490	"	.492	✓		"	
.965	"	.964	✓		"	
1.344	"	1.344	✓		"	
2.587	"	2.589	✓		"	
3.325	"	3.330	✓		"	
3.370	"	3.377	✓		"	
3.505	"	3.509	✓		"	
3.574	"	3.580	✓		"	
4.000	±.030	4.011	✓		"	
4.75	±.030	4.751	✓		"	
4.234	±.010	4.237	✓		"	
3.940	"	3.942	✓		"	
3.770	"	3.772	✓		"	
3.413	"	3.418	✓		"	
2.315	"	2.318	✓		"	
2.290	"	2.295	✓		"	
1.534	"	1.539	✓		"	
1.125	"	1.123	✓		"	
.718	"	.720	✓		"	
.600	"	.602	✓		"	
.176	±.015	.175	✓		MICS	
.239	±.015	.240	✓		MICS	

Measured by: LB	Audited by: S	Prototype Approval:	N/A
Date: 10/07/15	Date: 10/07/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Page #1



Receiving Report

Date: 9/10/28

Batch No: M110650

Supplier: MSCA

Part P/O: 8075

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipping Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ Work Order ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M02024735032		792	0	0	192	
M066176320X060		60	0	0	60	
M06617670625065		108	0	0	108	

Initials of receiver (if statement OK) Level 12 60

Production/Admin: 09/10/2103
 Date: 09/10/29
 Received/Costing: RC
 Initial: CX

Location _____

M7075763/500X150

Dart Aerospace Ltd

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Receiving Slip

Date
Feb 3, 2009

Page
1

Receipt Number
RCP00010129

Purchase From:

Magna Stainless
5775 rue Kieran
St Laurent, Quebec H4S 0A3
Canada

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-MAG002	PO00008045

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M303R0750	303 Round Bar 0.750 NOTE: AISI 304/316 NOT ACCEPTABLE MATERIAL: AISI 303 ROUND BAR B/N110680	124.0000	f	3.166666	392.67	Feb 03, 2009
	M6061T6B0250X0	6061-T6 Bar .250 x 4.00 PER AMS-QQ-A-200/8 OR AMS 4160 PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 BAR B/N110680	20.0000	f	2.650000	53.00	Feb 03, 2009 ✓
	M6061T6T1250W1	ALUM. RD TUBING 1.2 AS ABOVE B/N110680	160.0000	f	1.150000	184.00	Feb 03, 2009 ✓
	M6061T6T1500W1	6061T6 RD TUBE 1.50 X AS ABOVE B/N110680	60.0000	f	1.500000	90.00	Feb 03, 2009 ✓
	M6061T6TS1000W	6061T6 SQ TUBE 1.00 x OR AMS 4160 **** FLAT SQUARE EDGE**** AMS 4117/4128/4115/4116 OR PER AMS-QQ-A-200/8 SQUARE TUBING PER AMS-QQ-A-225/8 OR MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 B/N110680	140.0000	f	1.100000	154.00	Feb 03, 2009 ✓
	M304TR0875W065	304 round tube .875 x .0 MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING B/N110680	120.0000	f	8.750000	1,050.00	Feb 03, 2009 ✓

Comments:

PLEASE DO NOT SHIP ON THE 28TH & 29TH OF JANUARY



Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 631-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

I006135

Page: 1 of 1

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY, ON
K6A 1K7
Contact:

HAWKESBURY, ON
K6A 1K7
Ship Terms: PREPAID

MTR:Y

SPECIAL INSTRUCTIONS

DO NOT SHIP WILL ADVISE
HOLD

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		ERYCK BLAIS	(613) 632-5200	(613) 632-1053	CHANTAL	8045
Sales Order	Terms		Ship Via	Date Ordered	Date Required	Date Shipped
W002587	NET 30 DAYS		TARGET	10/23/08	11/21/08	01/28/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
6		PC	316L SMLS 7/8" OD .065 X 20' 120.00 FT / 6 PC FUEL SURCHARGE	L016423	YTO60922	6
Bundles: 1				Total Weight:	LB	

Received by: _____ Date: _____ Signature: _____

DART

Purchase Order

Date Jan 23, 2009	Page 1
Purchase Order Number PO00008045	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAXED
669663

Vendor Address:

Magna Stainless
5775 rue Kieran
St Laurent, Quebec H4S 0A3
Canada
Phone (514) 339-1211
Fax (514) 339-1105

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Jan 23, 2009	N30	yours	Jan 30, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
192.0000	M2024T3S032	2024-T3 .032 sheet Comments: MATERIAL: 2024-T3 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037	30/01/2009	No	3.645833	sf	700.00
✓ 120.0000 New 124	M303R0750	303 Round Bar 0.750 Comments: MATERIAL: AISI 303 ROUND BAR NOTE: AISI 304/316 NOT ACCEPTABLE	30/01/2009	No	3.166666	f	380.00
✓ 20.0000	M6061T6B0250X040	6061-T6 Bar .250 x 4.00 Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 BAR PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 PER AMS-QQ-A-200/8 OR AMS 4160	30/01/2009	No	2.650000	f	53.00
60.0000	M6061T6B0250X060	6061-T6 Bar .250 x 6.00 Comments: AS ABOVE	30/01/2009	No	4.050000	f	243.00
108.0000	M6061T6T0625W065	6061-T6 RD Tube .625 x . Comments: MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 ****SEAMLESS TUBING****	30/01/2009	No	4.770833	f	515.25
60.0000	M6061T6T1000W065	6061T6 RD TUBE 1.00 x . Comments: AS ABOVE	30/01/2009	No	5.320833	f	319.25
✓ 160.0000	M6061T6T1250W125	ALUM. RD TUBING 1.250 Comments: AS ABOVE	30/01/2009	No	1.150000	f	184.00
✓ 60.0000	M6061T6T1500W125	6061T6 RD TUBE 1.50 X . Comments: AS ABOVE	30/01/2009	No	1.500000	f	90.00
✓ 140.0000	M6061T6TS1000W12	6061T6 SQ TUBE 1.00 x 1 Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62	30/01/2009	No	1.100000	f	154.00

16 9/11/08

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

11/10/08

Continued on next page...



Purchase Order

Date Jan 23, 2009	Page 2
Purchase Order Number PO00008045	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

Vendor Address:

Magna Stainless
5775 rue Kieran
St Laurent, Quebec H4S 0A3
Canada
Phone (514) 339-1211
Fax (514) 339-1105

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Jan 23, 2009	N30	yours	Jan 30, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
80.0000	M304TR0875W065	SQUARE TUBING PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR PER AMS-QQ-A-200/8 OR AMS 4160 **** FLAT SQUARE EDGE**** 304 round tube .875 x .065 Comments: MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING	30/01/2009	No	8.750000	f	700.00
12.0000	M7075T6B1500X150	7075 T6 BAR 1.500 x 1.5 Comments: MATERIAL: 7075-T6 OR T651/T6511/T62 ALUM BAR PER AMS-QQ-A-225/9 OR AMS 4122/4123/4186/4187 OR PER AMS-QQ-A-200/11	30/01/2009	No	16.500000	f	198.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Comments:
PLEASE DO NOT SHIP ON THE 28TH & 29TH OF
JANUARY

Tax Summary:
GST
ONT PST

176.83
0.00

Less:
included tax

0.00

Subtotal

3,536.50

Total tax

176.83

Total purchase order in

CAD Dollars

3,713.33

Entered By: CL CLAVOIE

Approved By: U

ANALYSIS CERTIFICATE

Empire Resources, Inc.

One Parker Plaza
Fort Lee, NJ 07024-2937
United States
Tel : (201) 944-2200
Fax : (201) 944-2226
dfike@empireresources.com

EMPIRE Letter Ref # : EWR44185



Monday, 28 April, 2008

Date : April 28, 2008
Sales Contract # : E131500
Alloy-Temper : 6061-T6
Container # : EXTR20080414
Case # : EXC16740
Cast # : 18836
Die # : A10023
Specification : .250" X 4" X 20' FLAT BAR 6061, T6
Purchase Order : 073349-AD1
Customer Part # :

S
02/02/02

MADE IN THE USA

Chemical Composition (WT%)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Other Elements	
Min	0.40		0.15		0.8	0.04			Each Max	Total Max
Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Actual	= 0.6	= 0.22	= 0.21	= 0.07	= 0.87	= 0.06	= 0.02	= 0.017	= 0	

* Aluminum = Remainder

Actual cast analysis is retained on file.

Tensile Properties

Test No.	Yield (ksi)	Tensile (ksi)	Elong. (%)
1	36.3	38.2	16.3

ASTM B221-06. AMS-QQ-A-200/8-97

Ross Toombs

Authorized Signature

Ross Toombs
General Manager

CG755

Receiving Report

Date: 10/5/06

Batch No: M114608

Supplier: MAGNA

Dart P/O: 11792

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ N/A ☐
 Work Order 1010710 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin: 10/5/06
 Date LA
 Received/Costing LA
 Initial

Location _____



Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105



PACKING LIST

Page 1 of 1

I026730

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY, ON
K6A 1K7
Contact: CHANTAL

HAWKESBURY, ON
K6A 1K7
Ship Terms: PREPAID



SPECIAL INSTRUCTIONS

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		ERYCK BLAIS	(613) 632-5200	(613) 632-1053	PO11792	
Sales Order	Terms		Ship Via	Date Ordered	Date Required	Date Shipped
W029143	NET 30 DAYS		NIR:R-557065-1	05/03/10	05/06/10	05/06/10

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
1		PC	ALUMINUM FLATS AFL 6061 T6 1/4" x 4" x R/L			1
			46' 19 LB / 1 PC	L038946	19249	1
1		PC	AFL 6061 T6 1-1/2" x 2" x R/L			1
			12' 43 LB / 1 PC	L038947	20304268	1
Bundles: 1			Approx Weight:			62 LB

Rec'd 5/6

Received by: _____ Date: _____ Signature: _____

ANALYSIS CERTIFICATE

Empire Resources, Inc.

One Parker Plaza
Fort Lee, NJ 07024-2937
United States
Tel : (201) 944-2200
Fax : (201) 944-2226
tlehr@empireresources.com

ND 30924

EMPIRE Letter Ref # : EWR55924

EWR55924
Monday, 29 March, 2010

Date : March 29, 2010
Sales Contract # : E141131
Alloy-Temper : 6061-T6
Container # : EXTR20080611
Case # : EXC19165
Cast # : 19249
Die # : A10023
Specification : .250" X 4" X 16' RECT BAR 6061, T6
Purchase Order : P003974
Customer Part # :

8
10/05/10

2010016-19249

MADE IN THE USA

Chemical Composition (WT%)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Other Elements	
Min	0.40		0.15		0.8	0.04			Each Max	Total Max
Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Actual	= 0.58	= 0.2	= 0.19	= 0.04	= 0.83	= 0.05	= 0.01	= 0.015	= 0	

* Aluminum = Remainder

Actual cast analysis is retained on file.

Tensile Properties

Test No.	Yield (ksi)	Tensile (ksi)	Elong. (%)
1	35.6	38.6	16

ASTM B221-06 AMS-QQ-A-200/8-97

Ross Toombs

Authorized Signature

Ross Toombs
General Manager

Page 1 of 1

C 4905